

Work Order ID 50535



Page 1

July 14, 2009 1:57:41 PM

Item ID: D135-751-011
Revision ID: C
Item Name: Skidtube Installation

Accept



Setup Start



Stop



Start Date: 7/17/09 Start Qty: 1.00
Required Date: 7/30/09 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *U* Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3507	Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

8/09/10

John CL 09/08/05

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr 1/2-Drill #30 pilot holes using DT8678. Do not open holes. 1/3- Deburr holes.

119-7-15

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

119-7-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date & initial all entries

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Stop



QC: Date: SPC (Y/N): Date:

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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BE 07/07/06

170

Skid tubes

0.00



Skid tubes

Memo

0.00

Skid tubes

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.
and Detail "F" 1/2-Counter Sink X-BOLT holes as per Dwg D3507 1/3-Deburr
and blow out chips from inside of tube. 1/4-Bond web as per Dwg D3507 & QSI
015 A/R 241 Sike Flex Batch: 111557

etc. 6-1-31

D 11-7-16

A/R 11/16/79

BE 9-7-17

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

7 S 07/07/00 (x) f

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190 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Rivet D3506-1/-3 as per Dwg D3507.								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
210 	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

DE 09/07/20

=> S 08/02/21 @ /

EL 9-7-22

W/O:		WORK ORDER CHANGES					
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Reference:

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:20

FINISH TIME: 2:50

OVEN TEMPERATURE:

BR 09-07-22 (D)

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-08-05 (K)

240

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Install Wearplate &Ground Wire inserts as per Dwg D3507.

BR 09-08-05 (D)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S Carloslos



Memo

Inspect Inserts

0.00

260



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

1-Inspect for Foreign objects; 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 24i Sika Flex
Batch: M111057

Exp 10/01

Date: 11/12/06 13-Install Wearplates as per Dwg D3507, Note:Inst

WING WALK M112106

BL 09-08-5



BL 09-08-5



270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

=> S Carloslos



Memo

0.00

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

280

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/8/09 10 Sp

290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

=> Sorlosio

(H) 9

300

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D135-751-011 Location: 82 PPP Rev: 13

9/8/09 10 Sp

50535

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Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: 09-08-12

Handwritten text: MF 09-08-12

W/O:		WORK ORDER CHANGES					
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Date & initial all entries

Picklist Print

July 14, 2009 2:21:29 PM

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Work Order ID: 50534 534 u

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 7/17/09

Required Date: 7/30/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3C4A

Purchased

No

120

Each

270.0000

8.0000

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112082

270

270

Each

49.0000

1.0000

D2962-150RevA

Manufactured

No



3.540 Outer Tube, Extrut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28672

49

49

Each

31.0000

2.0000

D3504-1RevC

Manufactured

No



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

31234

31

31

112314 9/8/7 50

B 28672 ① H 7-75.

2 2E 09/07/7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 50534 535 ~



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 7/17/09

Required Date: 7/30/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3504-3RevC

Manufactured

No

170

Each

24.0000

1.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

24

31232

24

D3504-5RevC

Manufactured

No

170

Each

26.0000

2.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

26

36181

26

D3505-1RevA

Manufactured

No

170

Each

2.0000

1.0000



Web

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

46541

2

5053B

8

①

BE

9-7-16

July 14, 2009 2:21:29 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Qty: 1.00

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---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3506-1RevA

Manufactured

No

170

Each

6.0000

4.0000



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

6

46538

6

D3506-3RevA

Manufactured

No

170

Each

8.0000

2.0000



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

8

28964

4

46539

4

ALS7-1032-130

Purchased

No

240

Each

3,914.000

38.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3914

108606

52

111529

1862

111779

2000

110511

38

BR07-08-5.

July 14, 2009 2:21:29 PM

Shop Packet Print

Page 3

Dart Aerospace Ltd

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MS20601-AD4W3 Purchased

No

240

Each

354.0000

12.0000



Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

354

107823

54

111359

300

ALS4-1032-225 Purchased

No

260

Each

9,190.000

1.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9190

107441

28

110768 ✓

9162

AN3C4A Purchased

No

260

Each

270.0000

31.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

270

112082

270

112314

31

BR 09-08-5.

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AN526C1032R10

Purchased

No

260

Each

604.0000

2.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

604

108062 ✓

145

108167

35

110049

424

2

BR 02-08-5.

AN960C10L

Purchased

No

260

Each

4,964.000

33.0000



washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4964

103585 ✓

100

112116 ✓

4864

33

BR 02-08-5.

D2965-3RevB

Manufactured

No

260

Each

6.0000

1.0000



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

46582 ✓

6

1

BR 02-08-5.

July 14, 2009 2:21:29 PM

Shop Packet Print

Dart Aerospace Ltd

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D2965RevB		Manufactured	No			260	Each	29.0000	1.0000			
												
Cap, 105 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

50924

1 BR 09-08-5.

ST

29

43288

6

46800

23

D3492-041RevC

Manufactured

No

260

Each

27.0000

4.0000



Plug Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

27

43816

19

45561

8

D3492-043RevC

Manufactured

No

260

Each

0.0000

4.0000



Plug Assembly

34923

48273

4

BR 09-08-5.

Dart Aerospace Ltd

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D3492-047RevC		Manufactured	No			260	Each	66.0000	2.0000			
												
Plug Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 66

27776 3

28961 ✓ 45

39722 18

D3508-1RevC Manufactured No

260 Each 6.0000 1.0000



Wearplate



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 6

42973 ✓ 6

D3508-3RevC Manufactured No

260 Each 7.0000 1.0000



Wearplate



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 7

42250 1

46881 ✓ 6

2 *BL 09-08-5*

1 *BL 09-08-5*

1 *BL 09-08-5*

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8 / 12

Work Order ID: 50534 SSS u

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Comments:

Start Date: 7/17/09

Required Date: 7/30/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3508-5RevC		Manufactured	No			260	Each	5.0000	1.0000			
												
Wearplate												

Warehouse Loc Qty Loc Code
Location

Main Warehouse


ST

42251 ✓

5

5

1 BR 09-08-5.

D3508-7RevC		Manufactured	No			260	Each	9.0000	1.0000			
												
Wearplate												

Warehouse Loc Qty Loc Code
Location

Main Warehouse


ST

44518 ✓

9

9

1 BR 09-08-5.

D3558-1RevB		Manufactured	No			260	Each	4.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

42533

4

4

50925

1 BR 09-08-5.

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 2:21:29 PM

Work Order ID: 50534535w

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation



Comments:

Start Date: 7/17/09

Required Date: 7/30/09



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3558-3RevB		Manufactured	No			260	Each	12.0000	1.0000			
												
Gasket												



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	12	
45661 ✓	12	

1 BR 09-08-5.

D3558-5RevB		Manufactured	No			260	Each	5.0000	1.0000			
												
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
43244 ✓	5	

1 BR 09-08-5.

D3558-7RevB		Manufactured	No			260	Each	11.0000	1.0000			
												
Gasket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
36388	4	
43245	7	
50927		

1 BR 09-08-5.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50534 535 n

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 7/17/09

Required Date: 7/30/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1611-007 Purchased No 260 Each 448.0000 1.0000



O-RING

N
A

used on Assy/D 3492-047

09-09-21

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 448

103697 448

NAS1611-010 Purchased No 260 Each 362.0000 1.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 362

110715 67

110915 295

NAS1611-013 Purchased No 260 Each 330.0000 1.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 330

106513 11

111424 119

111758 200

N

A.

used on Assy/D 3492-043

mf 09-09-21

4

DRO9-08-5.

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 2:21:29 PM

Work Order ID: 50834 535u

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 7/17/09

Required Date: 7/30/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C5A Purchased

No

290

Each

510.0000

2.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

510

111424

8

111707 ✓

502

290

Each

7,153.000

8.0000

AN960JD10L Same as B50536 Purchased

No



Washer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

7237

101291

16

104885

153

105793

236

109632 ✓

1832

110985

5000

Main Warehouse

ST182

-84

109632

-84

112116 9/8/7
SP

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 14, 2009 2:21:29 PM

Work Order ID: 50534 535 n

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 7/17/09

Required Date: 7/30/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3512-1RevC		Manufactured	No			290	Each	5.0000	2.0000			
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Wearplate



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-------------------------------------	----------------	-----------------

Main Warehouse

ST	5	
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44642	5	
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[Handwritten signature]

51133

9/8/7

(R)

SV

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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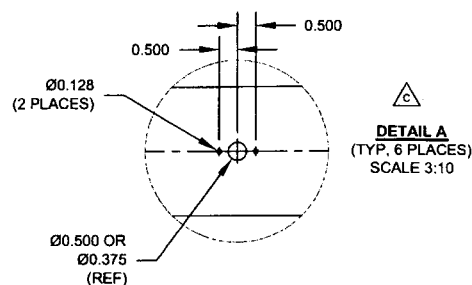
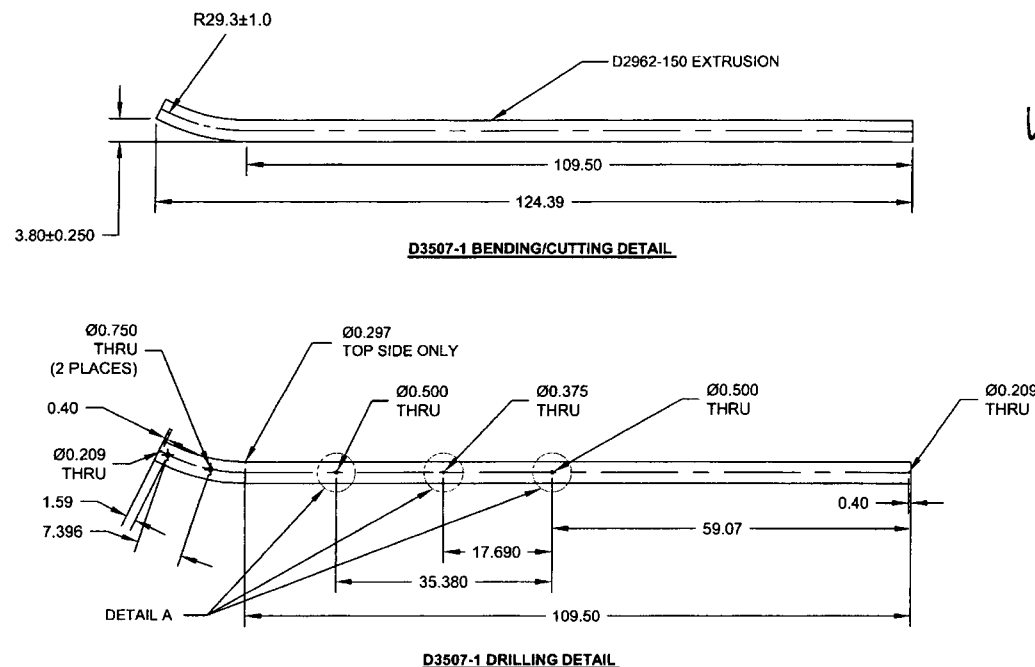
NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JC		
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	BP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



RELEASED
07.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

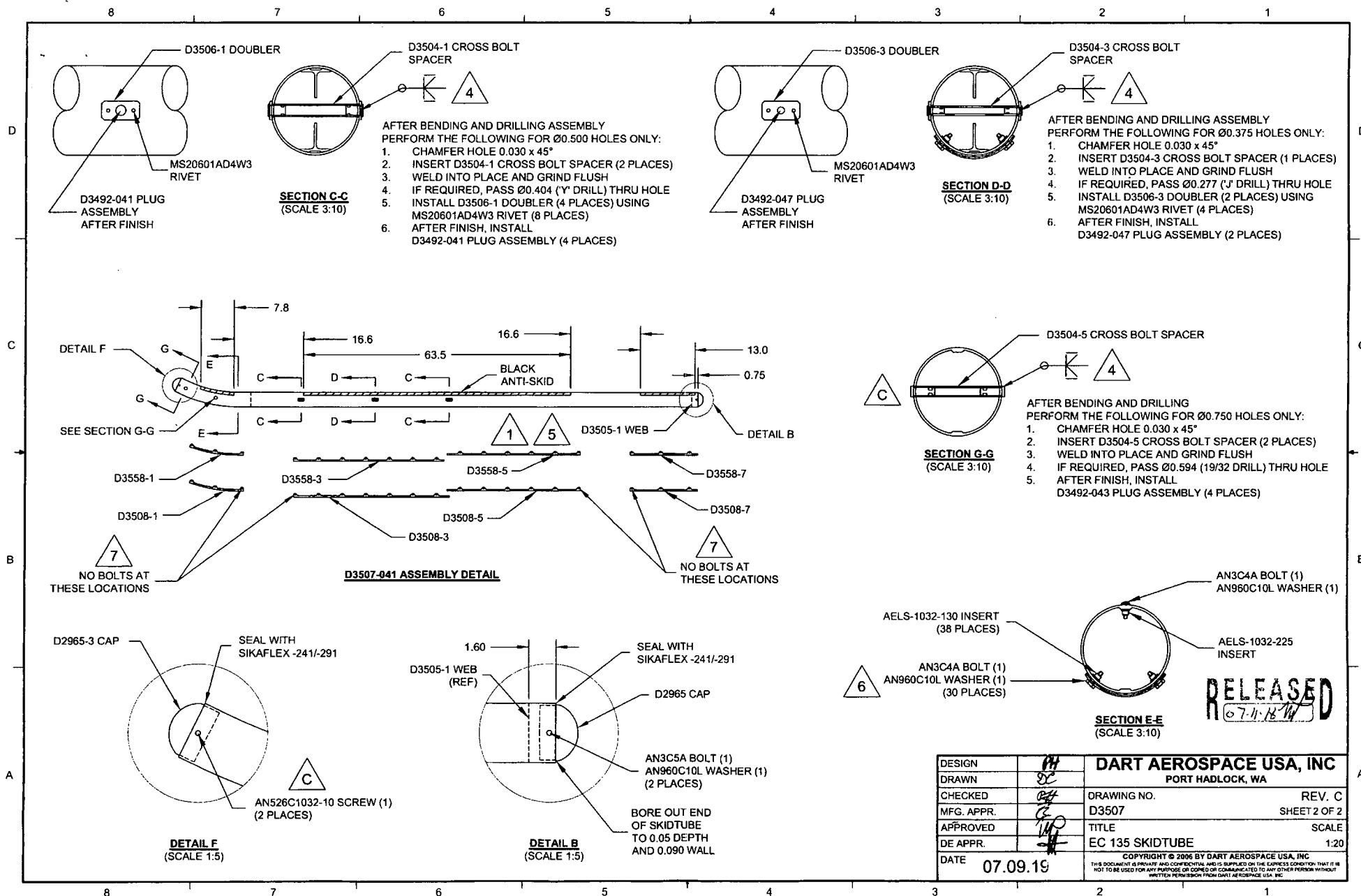
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/U 50535



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

1. Date & initial all entries

NO. 204

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 505370
Part number: D135 751 011
Description: SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

REFERENCE ONLY

Qualifier J. D. D. Date of Test Coupon 09-07-16

Welder Barclay Elliott Date of Test Coupon 09/07/16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld